

Work Order ID 54338

December 8, 2009 8:47:49 AM



Page 1

Item ID: D3768-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Outboard Leg, LH

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *08-12-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3768

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-CUT TUBE TO LENGH AS PER DWG D3768 02-DRILL TUBE USING
DT9044 AND AS PER DWG D3768 03-DEBURR

SAP 10-01-08

20

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/08

center
(720)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-06-11

(20) φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54338

December 8, 2009 8:47:49 AM



Page 2

Item ID:	D3768-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Front Outboard Leg, LH					
Start Date:	08/12/2009	Start Qty:	20.00		Cust Item ID:	
Required Date:	12/12/2009	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	Fire Red(Ref:4.3,5,10) per QSI005 4.3 <i>1102391</i> Memo START TIME: <i>3:15pm</i> OVEN TEMPERATURE: <i>3:45pm</i> FINISH TIME <i>320°F</i>	0.00 0.00		<i>7/11 10/01/11</i>		<i>(X20)</i>	<i>Ø</i>		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>BL 10-01-12</i>		<i>(20)</i>	<i>Ø</i>		
150 Packaging Packaging	Identify as per dwg & Stock Location: <i>250</i> Memo	0.00 0.00				<i>10-1-12</i>	<i>(20)</i>	<i>SP</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

December 8, 2009 8:47:49 AM



Accept

**Setup Start**

Stop



Start Date: 08/12/2009 **Start Qty:** 20.00

**Cust Item ID:**

Required Date: 16/12/2009: **Req'd Qty:** 20.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation	Description
1	Start of the program
2	Initialization of variables
3	Calculation of the sum of the first 10 natural numbers
4	Output of the result
5	End of the program

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

Plan Code

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

10/01/12 
MK 10-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 8:47:53 AM

Page 1

Work Order ID: 54338



Parent Item: D3768-3



Parent Item Name: Front Outboard Leg, LH

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

100

f

58.3994

17.9832



6061T6 RD TUBE 1.00 x .065w

SAD 10-01-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

58.3994082

110778

2.18

111029

56.2194082

M113511

17.9832

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1
SHOWN
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT
WORK OF
NO. 54338

PL 09-12-6



D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH





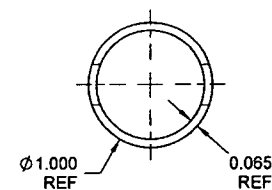
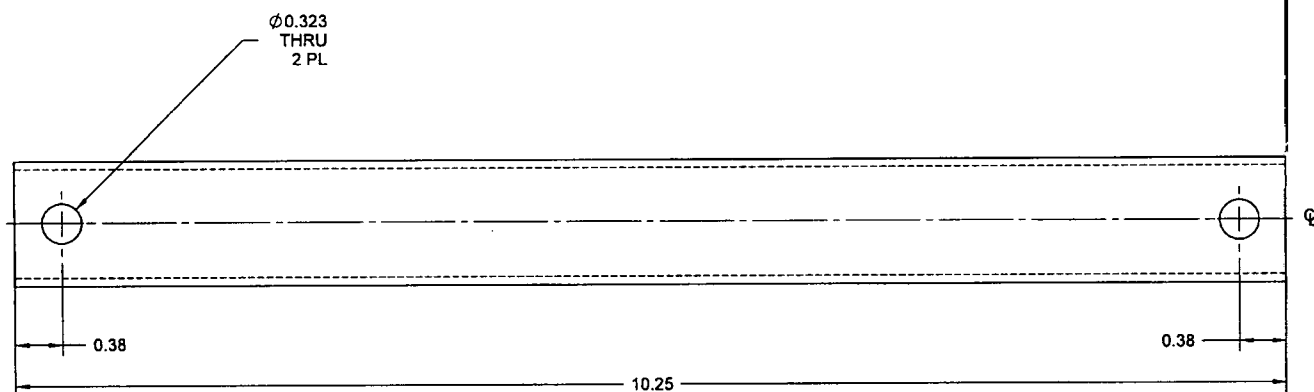
D3768-4 FRONT OUTBOARD LEG, RH

RELEASED
08-06-13

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
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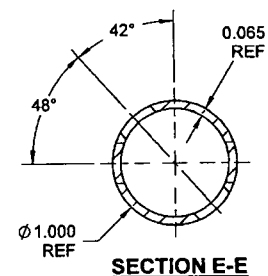
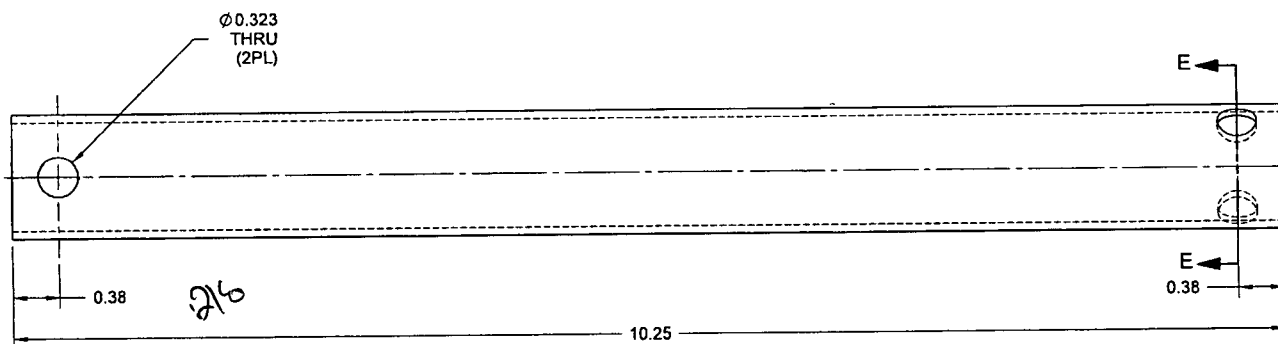


D3768-1 FRONT INBOARD LEG

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08-06-16

W/0 54335

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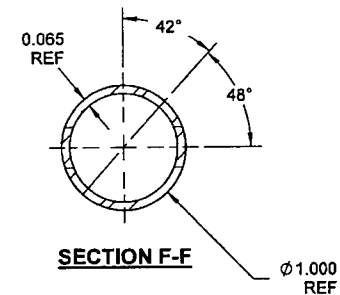
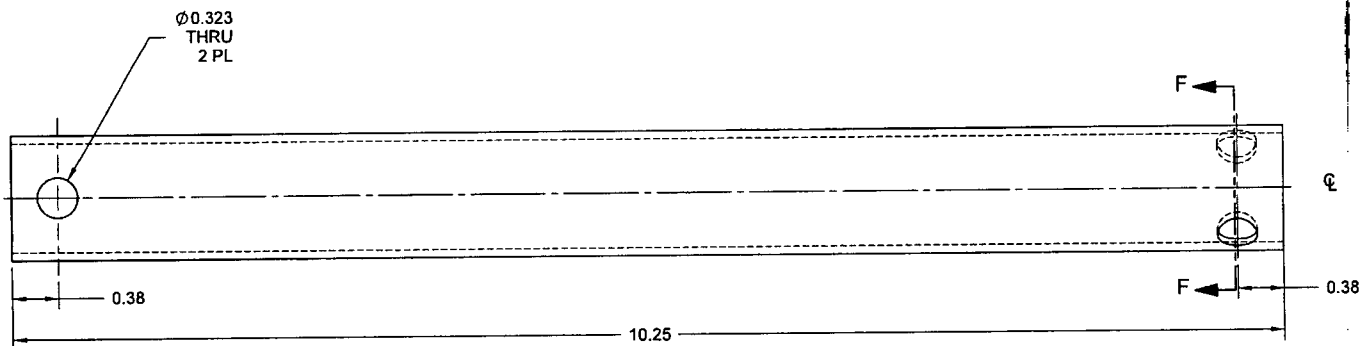


D3768-3 FRONT OUTBOARD LEG, LH

RELEASED
68-06-14/14

W/D 54338

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D3768-4 FRONT OUTBOARD LEG, RH

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08-06-11

W/05433F

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